

Work Order ID 91224

91224

Page 1

@October-03-12 2:41:37 PM

Item ID: D2662-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, RH In 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12-10-04 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2662 | Rev E | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | HAAS CNC VERTICAL MACHINING #1 | 0.00 | | | | | | | |
| HAAS 1 | Memo | | | | | | | | |
| HAAS CNC vertical machine #1 | Program part number and batch number. Inspect part number and batch number are programmed | | | | | | | | |
| | MACHINE AS PER FOLIO FB069 & DWG DWG REV: <u>E</u> FOLIO REV: <u>AA</u> | | | | | | | | |
| 110 | | 0.00 | | | | | | | |
| *110* | CONVENTIONAL MILLING MACHINE | 0.00 | | | | | | | |
| Mill Conv | Memo | | | | | | | | |
| Conventional Milling Machine | Machine Keyway and inspect per attached dimension sheet | | | | | | | | |

DAS
08
9-89

B.A 12/10/25

FK 12/10/27

30

FK 12/10/29

30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|------------------------------------|--|--------------------------------------|---|--------------------------|--|------------------------|---------------------|---------------------|--|--|------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | | | | | | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | |
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| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| FAULT CATEGORY | | | | |
|---|---|---|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Work Order ID 91224

October-03-12 2:41:37 PM

91224

Page 2

Item ID: D2662-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH In 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

DAS
08 12/10/25
2-89 J.A.
F.K. 12/10/27

30 0

DAS
14 12/10/29
2-89

30 0

30 0 BL 12/10-30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|------------------------------------|--|--------------------------------------|---|--------------------------|---|------------------------|---------------------|---------------------|--|--|------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| FAULT CATEGORY | | | | |
|--|---|---|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Work Order ID 91224

October-03-12 2:41:37 PM

91224

Page 3

Item ID: D2662-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH In 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200 F

2:20

30 X ~~φ~~

M/f
12/10/30

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

30 ~~φ~~ 12-10-30



170

Identify as per dwg & Stock Location

0.00

170

Packaging

Memo

0.00

Packaging

30 ~~φ~~ 12/10/31

433

M1 22878

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | |
|---|-------------|-------------|---|---|--------------------------|---|------------------------|---------------------|--|--|---|--|
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| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

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October-03-12 2:41:37 PM

91224

Page 4

Item ID: D2662-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH In 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 30.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/10/31 *[Signature]*

[Signature] 12-10-31

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|------------------------------------|--|---|---|----------------------|--|----------------|--------------|---|--|--|------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Doc/Data <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | | | | | | | | | | | | | | | | | |

Picklist Print

October-03-12 2:41:40 PM

Page 1

Work Order ID: 91224

91224

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 03/10/2012

Required Date: 12/11/2012

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house

processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-001 | | Manufactured | No | | | 100 | Each | 42.0000 | 1 | 30 | | | |

D6101-001

Saddle Billet

**

15.0 12/10/25

Location

Loc Qty

Loc Code

MAT040

38

69677

2

76836

1

81923

1

→ 85433

11

87606

11

90152

12

MAT042

4

83309

4

→ 90562

11

20.0

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | |
|---|-------------|-------------|---|---|--------------------------|---|------------------------|---------------------|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to Q/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 91224 |
| Description: 206 Saddle, Inboard, Left side | | Part Number: | D2662-2 |
| Inspection Dwg: D2662 Rev: E DSK: Rev: | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|-----|-------|-------|----------------|--------------------------|--------|-------|-------|--------|
| | | | | 1 | 2 | 3 | 4 | 5 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | 0.258 | 0.258 | 0.258 | 0.258 | 0.258 |
| C | 0.315 | 0.322 | | 0.316 | 0.316 | 0.316 | 0.316 | 0.316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 0.100 | 0.140 | | 0.128 | 0.128 | 0.128 | 0.128 | 0.128 |
| G | 0.210 | 0.230 | | 0.224 | 0.224 | 0.223 | 0.221 | 0.223 |
| H | 0.615 | 0.685 | | 0.685 | 0.685 | 0.685 | 0.685 | 0.685 |
| I | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | 2.490 |
| J | 1.313 | 1.343 | | 1.329 | 1.328 | 1.328 | 1.327 | 1.328 |
| K | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | 0.188 |
| L | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | 0.500 |
| M | 1.125 | 1.145 | | 1.1357 | 1.139 | 1.139 | 1.138 | 1.1355 |
| N | 0.100 | 0.180 | | 0.135 | 0.135 | 0.135 | 0.135 | 0.135 |
| O | 0.100 | 0.140 | | 0.140 | 0.138 | 0.138 | 0.138 | 0.138 |
| P | 0.240 | 0.260 | | 0.253 | 0.251 | 0.252 | 0.252 | 0.252 |
| Q | 0.677 | 0.697 | | 0.687 | 0.687 | 0.687 | 0.687 | 0.687 |
| R | 0.540 | 0.560 | | 0.551 | 0.551 | 0.551 | 0.551 | 0.551 |
| S | 0.912 | 0.932 | | 0.925 | 0.922 | 0.922 | 0.922 | 0.922 |
| T | 0.787 | 0.807 | | 0.799 | 0.797 | 0.797 | 0.797 | 0.797 |
| U | 5.990 | 6.010 | | 6.001 | 6.001 | 6.001 | 6.001 | 6.001 |
| V | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| W | 0.490 | 0.510 | | 0.499 | 0.499 | 0.499 | 0.499 | 0.499 |
| X | 0.312 | 0.319 | | 0.314 | 0.314 | 0.314 | 0.314 | 0.314 |
| Y | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| Z | | | | | | | | |
| AA | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AB | 0.490 | 0.510 | | 0.500 | 0.500 | 0.500 | 0.500 | 0.500 |
| AC | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AD | 0.100 | 0.140 | | 0.128 | 0.126 | 0.125 | 0.131 | 0.128 |
| AE | 0.235 | 0.240 | | .236 | .236 | .237 | .236 | .237 |
| AF | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | .512 |
| AG | 0.100 | 0.120 | | .110 | .110 | .110 | .110 | .111 |
| AH | 1.565 | 1.585 | | 1.576 | 1.5795 | 1.579 | 1.578 | 1.577 |

Accept/Reject

| | |
|-----------------------------------|-----------------------|
| Measured by: 08 / F.K. DAS | Date: 12/10/25 |
| Audited by: 14 | Date: 12/10/29 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| D | 02.12.12 | R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 12.01.10 | Revised per drawing revision E | KJ | |
| H | 12.03.08 | Dimension AH added, O revised | KJ | |

| | | | | | |
|--|--|--|--|-----------------------------|--|
| DART AEROSPACE LTD | | | | Work Order: 91224 | |
| Description: 206 Saddle, Inboard, Left side | | | | Part Number: D2662-2 | |
| Inspection Dwg: D2662 Rev: E DSK: Rev: | | | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|-----|-------|-------|----------------|--------------------------|-------|-------|--------|-------|
| | | | | #1 | #2 | #3 | #4 | #10 |
| A | 3.611 | 3.621 | | 3.316 | 3.316 | 3.316 | 3.316 | 3.316 |
| B | 0.256 | 0.263 | | 0.258 | 0.258 | 0.258 | 0.258 | 0.258 |
| C | 0.315 | 0.322 | | 0.316 | 0.316 | 0.316 | 0.316 | 0.316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 0.100 | 0.140 | | 0.128 | 0.128 | 0.128 | 0.128 | 0.128 |
| G | 0.210 | 0.230 | | 0.222 | 0.222 | 0.226 | 0.224 | 0.223 |
| H | 0.615 | 0.685 | | 0.685 | 0.685 | 0.685 | 0.685 | 0.685 |
| I | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | 2.490 |
| J | 1.313 | 1.343 | | 1.327 | 1.327 | 1.331 | 1.328 | 1.328 |
| K | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | 0.188 |
| L | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | 0.500 |
| M | 1.125 | 1.145 | | 1.137 | 1.142 | 1.139 | 1.1375 | 1.137 |
| N | 0.100 | 0.180 | | 0.135 | 0.135 | 0.135 | 0.135 | 0.135 |
| O | 0.100 | 0.140 | | 0.138 | 0.140 | 0.138 | 0.139 | 0.138 |
| P | 0.240 | 0.260 | | 0.254 | 0.252 | 0.251 | 0.252 | 0.252 |
| Q | 0.677 | 0.697 | | 0.687 | 0.687 | 0.687 | 0.687 | 0.687 |
| R | 0.540 | 0.560 | | 0.550 | 0.550 | 0.550 | 0.550 | 0.550 |
| S | 0.912 | 0.932 | | 0.922 | 0.922 | 0.922 | 0.922 | 0.922 |
| T | 0.787 | 0.807 | | 0.797 | 0.797 | 0.797 | 0.797 | 0.797 |
| U | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| V | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| W | 0.490 | 0.510 | | 0.499 | 0.499 | 0.499 | 0.498 | 0.497 |
| X | 0.312 | 0.319 | | 0.314 | 0.314 | 0.314 | 0.314 | 0.314 |
| Y | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| Z | | | | | | | | |
| AA | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AB | 0.490 | 0.510 | | 0.500 | 0.500 | 0.500 | 0.500 | 0.500 |
| AC | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AD | 0.100 | 0.140 | | 0.132 | 0.131 | 0.131 | 0.132 | 0.132 |
| AE | 0.235 | 0.240 | | .236 | .236 | .236 | .236 | .236 |
| AF | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | .512 |
| AG | 0.100 | 0.120 | | .110 | .110 | .110 | .110 | .110 |
| AH | 1.565 | 1.585 | | 1.577 | 1.582 | 1.579 | 1.577 | 1.577 |

Accept/Reject

| | |
|-----------------------------------|-----------------------|
| Measured by: DAS 08 / F.K. | Date: 12/10/25 |
| Audited by: 14 | Date: 12/10/29 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| D | 02.12.12 | R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 12.01.10 | Revised per drawing revision E | KJ | |
| H | 12.03.08 | Dimension AH added, O revised | KJ | |

| | | | | | |
|--|--|--|--|-----------------------------|--|
| DART AEROSPACE LTD | | | | Work Order: 91224 | |
| Description: 206 Saddle, Inboard, Left side | | | | Part Number: D2662-2 | |
| Inspection Dwg: D2662 Rev: E DSK: Rev: | | | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|-----|-------|-------|----------------|--------------------------|-------|-------|--------|-------|
| | | | | 11 | 12 | 13 | 14 | 15 |
| A | 3.611 | 3.621 | | 3.316 | 3.316 | 3.316 | 3.316 | 3.316 |
| B | 0.256 | 0.263 | | 0.258 | 0.258 | 0.258 | 0.258 | 0.258 |
| C | 0.315 | 0.322 | | 0.316 | 0.316 | 0.316 | 0.316 | 0.316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 0.100 | 0.140 | | 0.127 | 0.128 | .128 | .127 | .127 |
| G | 0.210 | 0.230 | | 0.223 | 0.223 | .223 | .223 | .223 |
| H | 0.615 | 0.685 | | 0.685 | 0.685 | 0.685 | 0.685 | 0.685 |
| I | 2.470 | 2.510 | | 2.490 | 2.490 | 2.490 | 2.490 | 2.490 |
| J | 1.313 | 1.343 | | 1.332 | 1.328 | 1.328 | 1.328 | 1.327 |
| K | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | 0.188 |
| L | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | 0.500 |
| M | 1.125 | 1.145 | | 1.137 | 1.138 | 1.138 | 1.1365 | 1.136 |
| N | 0.100 | 0.180 | | 0.135 | 0.135 | 0.135 | 0.135 | 0.135 |
| O | 0.100 | 0.140 | | 0.138 | 0.138 | .140 | .140 | .140 |
| P | 0.240 | 0.260 | | 0.252 | 0.252 | .254 | .253 | .253 |
| Q | 0.677 | 0.697 | | 0.687 | 0.687 | 0.687 | 0.687 | 0.687 |
| R | 0.540 | 0.560 | | 0.550 | 0.550 | 0.550 | 0.550 | 0.550 |
| S | 0.912 | 0.932 | | 0.922 | 0.922 | 0.922 | 0.922 | 0.922 |
| T | 0.787 | 0.807 | | 0.797 | 0.797 | 0.797 | 0.797 | 0.797 |
| U | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| V | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| W | 0.490 | 0.510 | | 0.498 | 0.498 | .498 | .500 | .498 |
| X | 0.312 | 0.319 | | 0.314 | 0.314 | 0.314 | 0.314 | 0.314 |
| Y | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| Z | | | | | | | | |
| AA | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AB | 0.490 | 0.510 | | 0.500 | 0.500 | 0.500 | 0.500 | 0.500 |
| AC | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AD | 0.100 | 0.140 | | 0.132 | 0.132 | .131 | .132 | .134 |
| AE | 0.235 | 0.240 | | .236 | .236 | .236 | .236 | .236 |
| AF | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | .512 |
| AG | 0.100 | 0.120 | | .110 | .110 | .110 | .110 | .110 |
| AH | 1.565 | 1.585 | | 1.577 | 1.578 | 1.578 | 1.577 | 1.575 |

| | | | |
|---|--|------------------------------|--|
| Measured by: <u>08</u> / <u>15</u> <u>12/10/27</u> | | Date: <u>12/10/26</u> | |
| Audited by: <u>14</u> <u>12/10/29</u> | | Date: <u>12/10/29</u> | |
| Prototype Approval: <u>08</u> | | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| D | 02.12.12 | R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 12.01.10 | Revised per drawing revision E | KJ | |
| H | 12.03.08 | Dimension AH added, O revised | KJ | <u>M</u> |

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 91224 |
| Description: 206 Saddle, Inboard, Left side | | Part Number: | D2662-2 |
| Inspection Dwg: D2662 Rev: E DSK: Rev: | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| | | | | 16 | 17 | 18 | 19 | 20 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | .258 | .258 | .258 | .258 | .258 |
| C | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | .316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 0.100 | 0.140 | | .127 | .128 | .129 | .128 | .126 |
| G | 0.210 | 0.230 | | .223 | .223 | .223 | .224 | .223 |
| H | 0.615 | 0.685 | | .685 | .685 | .685 | .685 | .685 |
| I | 2.470 | 2.510 | | 2.491 | 2.491 | 2.491 | 2.491 | 2.491 |
| J | 1.313 | 1.343 | | 1.328 | 1.327 | 1.328 | 1.329 | 1.327 |
| K | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| L | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | .500 |
| M | 1.125 | 1.145 | | 1.135 | 1.136 | 1.138 | 1.137 | 1.135 |
| N | 0.100 | 0.180 | | .135 | .135 | .135 | .135 | .135 |
| O | 0.100 | 0.140 | | .140 | .140 | .140 | .140 | .140 |
| P | 0.240 | 0.260 | | .254 | .254 | .254 | .253 | .253 |
| Q | 0.677 | 0.697 | | .687 | .687 | .687 | .687 | .687 |
| R | 0.540 | 0.560 | | .550 | .550 | .550 | .550 | .550 |
| S | 0.912 | 0.932 | | .922 | .922 | .922 | .922 | .922 |
| T | 0.787 | 0.807 | | .797 | .797 | .797 | .798 | .798 |
| U | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| V | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| W | 0.490 | 0.510 | | .497 | .497 | .498 | .497 | .498 |
| X | 0.312 | 0.319 | | .314 | .314 | .314 | .314 | .314 |
| Y | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| Z | | | | | | | | |
| AA | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AB | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | .500 |
| AC | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AD | 0.100 | 0.140 | | .132 | .132 | .132 | .132 | .133 |
| AE | 0.235 | 0.240 | | .236 | .236 | .236 | .236 | .236 |
| AF | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | .512 |
| AG | 0.100 | 0.120 | | .110 | .110 | .110 | .110 | .110 |
| AH | 1.565 | 1.585 | | 1.575 | 1.575 | 1.578 | 1.577 | 1.575 |
| Accept/Reject | | | | | | | | |

| | |
|----------------------------|-----------------------|
| Measured by: F.K. | Date: 12/10/27 |
| Audited by: | Date: 12/10/29 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| D | 02.12.12 | R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 12.01.10 | Revised per drawing revision E | KJ | |
| H | 12.03.08 | Dimension AH added, O revised | KJ | |

| | | | | | |
|--|--|--|--|-----------------------------|--|
| DART AEROSPACE LTD | | | | Work Order: 91224 | |
| Description: 206 Saddle, Inboard, Left side | | | | Part Number: D2662-2 | |
| Inspection Dwg: D2662 Rev: E DSK: Rev: | | | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|-----|-------|-------|----------------|--------------------------|-------|-------|-------|--------|
| | | | | 21 | 22 | 23 | 24 | 25 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | .258 | .258 | .258 | .258 | .258 |
| C | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | .316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 0.100 | 0.140 | | .126 | .126 | .125 | .125 | .125 |
| G | 0.210 | 0.230 | | .223 | .223 | .223 | .223 | .223 |
| H | 0.615 | 0.685 | | .685 | .685 | .685 | .685 | .685 |
| I | 2.470 | 2.510 | | 2.491 | 2.491 | 2.491 | 2.491 | 2.491 |
| J | 1.313 | 1.343 | | 1.326 | 1.327 | 1.326 | 1.325 | 1.326 |
| K | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| L | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | .500 |
| M | 1.125 | 1.145 | | 1.135 | 1.136 | 1.135 | 1.134 | 1.1345 |
| N | 0.100 | 0.180 | | .135 | .135 | .135 | .135 | .135 |
| O | 0.100 | 0.140 | | .140 | .140 | .140 | .140 | .140 |
| P | 0.240 | 0.260 | | .253 | .253 | .253 | .253 | .253 |
| Q | 0.677 | 0.697 | | .687 | .687 | .687 | .687 | .687 |
| R | 0.540 | 0.560 | | .550 | .550 | .550 | .550 | .550 |
| S | 0.912 | 0.932 | | .922 | .921 | .921 | .922 | .922 |
| T | 0.787 | 0.807 | | .798 | .798 | .798 | .797 | .797 |
| U | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.000 | 6.000 |
| V | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| W | 0.490 | 0.510 | | .497 | .497 | .497 | .497 | .497 |
| X | 0.312 | 0.319 | | .314 | .314 | .314 | .314 | .314 |
| Y | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| Z | | | | | | | | |
| AA | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AB | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | .500 |
| AC | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AD | 0.100 | 0.140 | | .132 | .132 | .132 | .133 | .132 |
| AE | 0.235 | 0.240 | | .236 | .236 | .237 | .237 | .238 |
| AF | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | .512 |
| AG | 0.100 | 0.120 | | .110 | .110 | .111 | .111 | .112 |
| AH | 1.565 | 1.585 | | 1.575 | 1.576 | 1.575 | 1.574 | 1.574 |

Accept/Reject

| | |
|----------------------------|-----------------------|
| Measured by: FK- DA | Date: 12/10/27 |
| Audited by: 14 | Date: 12/10/29 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| D | 02.12.12 | R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 12.01.10 | Revised per drawing revision E | KJ | |
| H | 12.03.08 | Dimension AH added, O revised | KJ | |

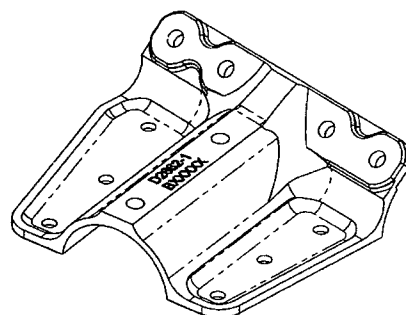
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|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 91224 |
| Description: 206 Saddle, Inboard, Left side | | Part Number: | D2662-2 |
| Inspection Dwg: D2662 Rev: E DSK: Rev: | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

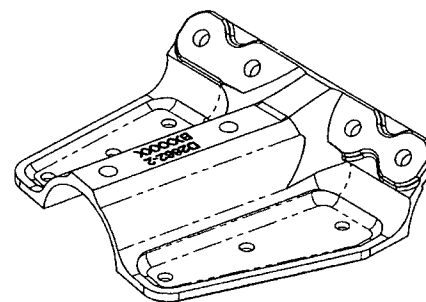
| Dim | Min | Max | Go/No Go Gauge | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| | | | | 26 | 27 | 28 | 29 | 30 |
| A | 3.611 | 3.621 | | 3.616 | 3.616 | 3.616 | 3.616 | 3.616 |
| B | 0.256 | 0.263 | | .258 | .258 | .258 | .258 | .258 |
| C | 0.315 | 0.322 | | .316 | .316 | .316 | .316 | .316 |
| D | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| E | 1.674 | 1.684 | | 1.679 | 1.679 | 1.679 | 1.679 | 1.679 |
| F | 0.100 | 0.140 | | .127 | .126 | .129 | .127 | .127 |
| G | 0.210 | 0.230 | | .223 | .223 | .225 | .223 | .223 |
| H | 0.615 | 0.685 | | .685 | .685 | .685 | .685 | .685 |
| I | 2.470 | 2.510 | | 2.491 | 2.491 | 2.491 | 2.491 | 2.491 |
| J | 1.313 | 1.343 | | 1.327 | 1.327 | 1.329 | 1.327 | 1.327 |
| K | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| L | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | .500 |
| M | 1.125 | 1.145 | | 1.134 | 1.135 | 1.139 | 1.136 | 1.136 |
| N | 0.100 | 0.180 | | .135 | .135 | .135 | .135 | .135 |
| O | 0.100 | 0.140 | | .140 | .140 | .140 | .140 | .140 |
| P | 0.240 | 0.260 | | .253 | .253 | .253 | .253 | .253 |
| Q | 0.677 | 0.697 | | .687 | .687 | .687 | .687 | .687 |
| R | 0.540 | 0.560 | | .550 | .550 | .550 | .549 | .550 |
| S | 0.912 | 0.932 | | .922 | .922 | .922 | .922 | .922 |
| T | 0.787 | 0.807 | | .797 | .797 | .797 | .797 | .797 |
| U | 5.990 | 6.010 | | 6.000 | 6.000 | 6.000 | 6.001 | 6.000 |
| V | 4.995 | 5.005 | | 5.000 | 5.000 | 5.000 | 5.000 | 5.000 |
| W | 0.490 | 0.510 | | .498 | .497 | .497 | .497 | .497 |
| X | 0.312 | 0.319 | | .314 | .314 | .314 | .314 | .314 |
| Y | 0.990 | 1.010 | | 1.000 | 1.000 | 1.000 | 1.000 | 1.000 |
| Z | | | | | | | | |
| AA | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| AB | 0.490 | 0.510 | | .500 | .500 | .500 | .500 | .500 |
| AC | 3.745 | 3.755 | | 3.750 | 3.750 | 3.750 | 3.750 | 3.750 |
| AD | 0.100 | 0.140 | | .132 | .132 | .132 | .132 | .132 |
| AE | 0.235 | 0.240 | | .236 | .236 | .236 | .236 | .236 |
| AF | 0.510 | 0.515 | | .512 | .512 | .512 | .512 | .512 |
| AG | 0.100 | 0.120 | | .110 | .110 | .110 | .110 | .110 |
| AH | 1.565 | 1.585 | | 1.574 | 1.575 | 1.578 | 1.576 | 1.576 |
| Accept/Reject | | | | | | | | |

| | |
|---------------------------------|-----------------------|
| Measured by: EK 12/10/28 | Date: 12/10/28 |
| Audited by: 14 | Date: 12/10/29 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| D | 02.12.12 | R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B | KJ/RF | |
| E | 06.07.05 | Revised per drawing revision C | KJ/JLM | |
| F | 07.03.21 | Revised per drawing revision D | KJ/JLM | |
| G | 12.01.10 | Revised per drawing revision E | KJ | |
| H | 12.03.08 | Dimension AH added, O revised | KJ | M |



D2662-1 SADDLE, INSIDE, LH



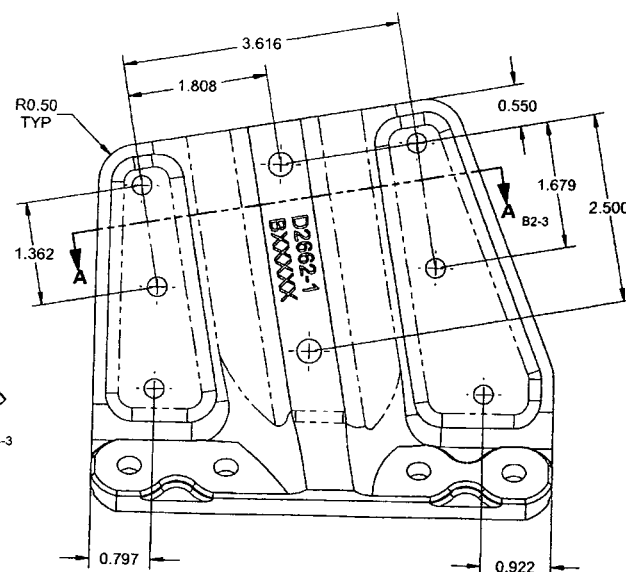
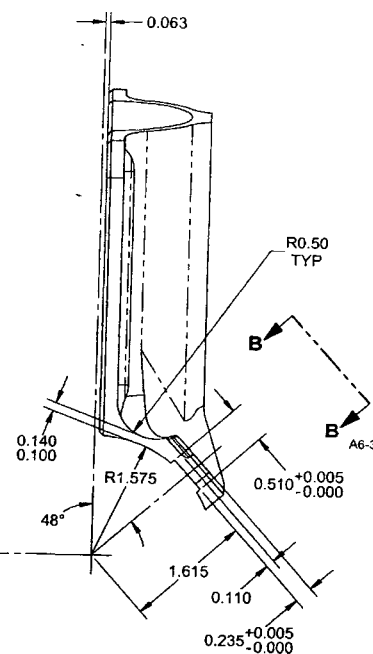
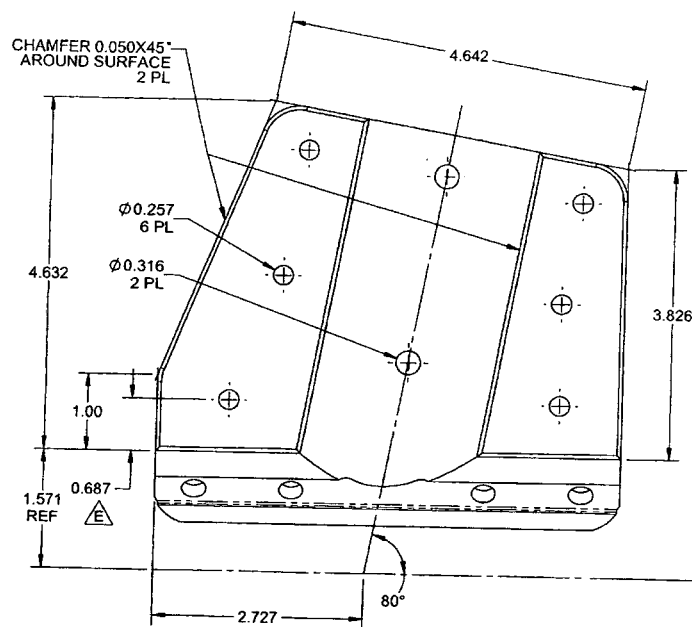
D2662-2 SADDLE, INSIDE, RH

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 91224 MJS
12-10-04

RELEASED
2011-11-16

| | | | |
|---|---|--------------------------------------|--------------|
| E | REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935 | CP | 11.10.31 |
| D | R0.188 WAS R0.30, Ø0.316 WAS Ø0.313 | CB | 06.11.08 |
| C | INCORP' DEO 9122/9102/9095/9137 | CB | 06.05.29 |
| B | ANGLE AND NOTES ADDED | KE | 97.07.11 |
| A | NEW ISSUE | DS | 97.03.25 |
| REV | DESCRIPTION | BY | DATE |
| DESIGN | <i>g</i> | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | <i>AS</i> | DRAWING NO. | REV. E |
| CHECKED | <i>AS</i> | D2662 | SHEET 1 OF 5 |
| MFG. APPR. | <i>AS</i> | TITLE | SCALE |
| APPROVED | <i>AS</i> | SADDLE, INSIDE | NTS |
| DE APPR. | <i>AS</i> | DATE 11.10.31 | |
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91224



D2662-1 SADDLE, INSIDE, LH

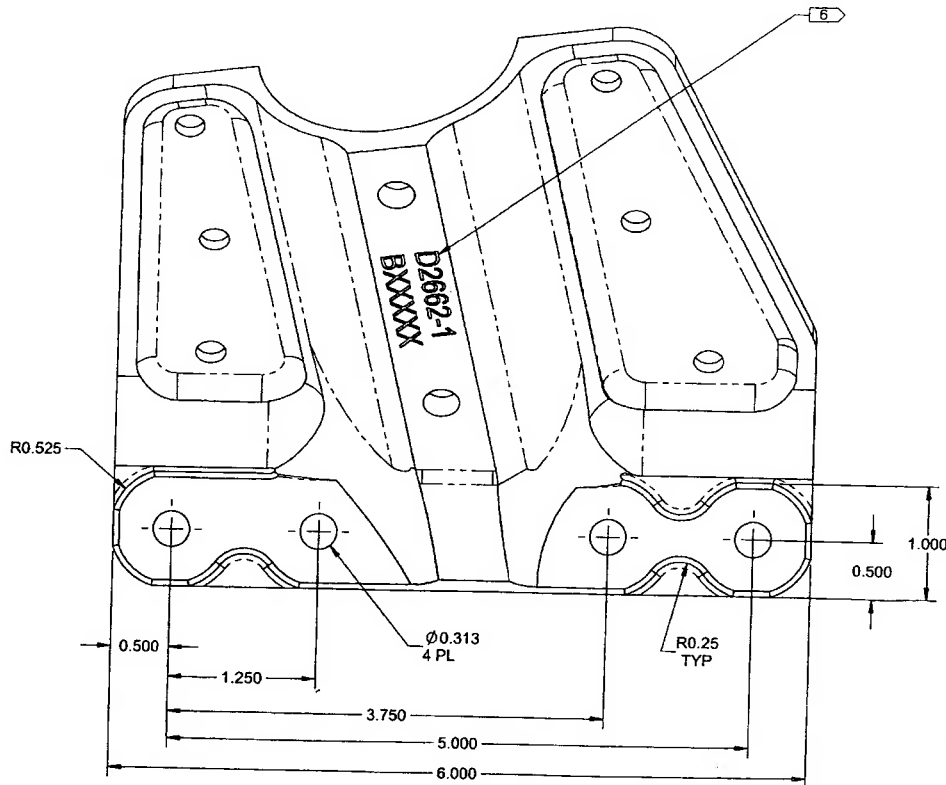
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209 MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING) USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

RELEASE
2011-11-16

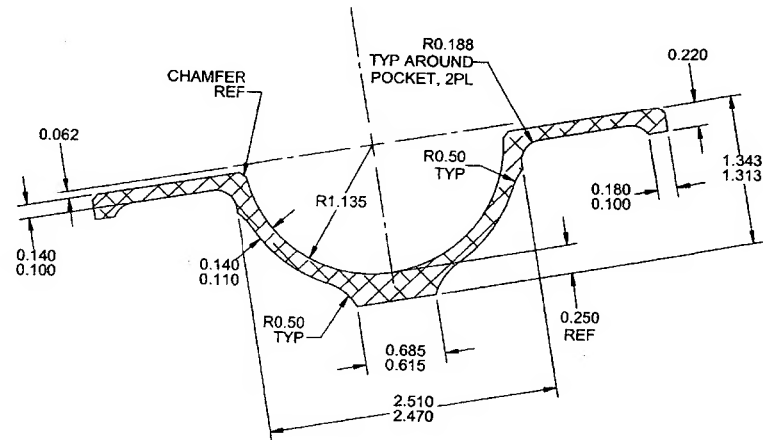
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| DESIGN | | DART AEROSPACE USA, INC. |
| DRAWN | | KENT, WA |
| CHECKED | | DRAWING NO. D2662 |
| MFG. APPR. | | REV. E |
| APPROVED | | SHEET 2 OF 5 |
| DE APPR. | | TITLE SADDLE, INSIDE |
| DATE | 11.10.31 | SCALE NTS |

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91224



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A
SCALE 1.5X C1-2

RELEASED
2011-11-16

| | | | |
|------------|--------------------|---|--------------|
| DESIGN | 90 | DART AEROSPACE USA, INC. | |
| DRAWN | 90 | KENT, WA | |
| CHECKED | AS | DRAWING NO. | REV. E |
| MFG. APPR. | <i>[Signature]</i> | D2662 | SHEET 3 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SADDLE, INSIDE | NTS |
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CHAMFER 0.050X45°
AROUND SURFACE
2 PL

$\phi 0.257$
6 PL

$\phi 0.316$
2 PL

1.571 REF

80°

2.727

0.687

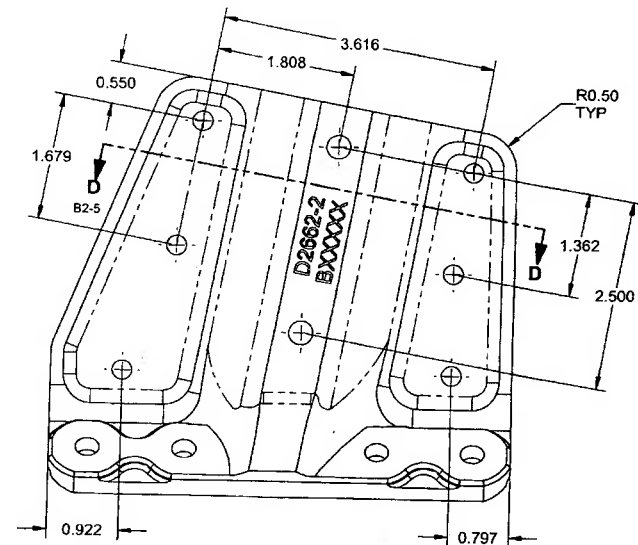
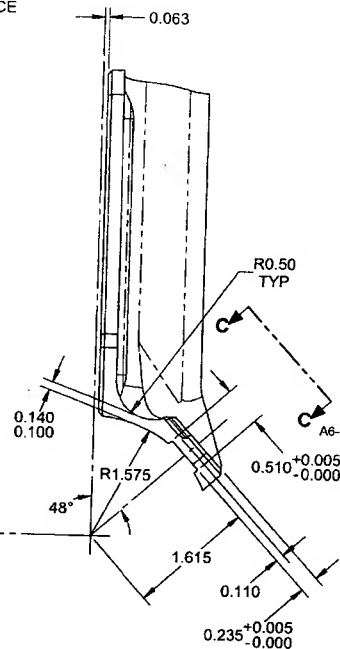
1.00

4.632

4.642

3.826

0.00



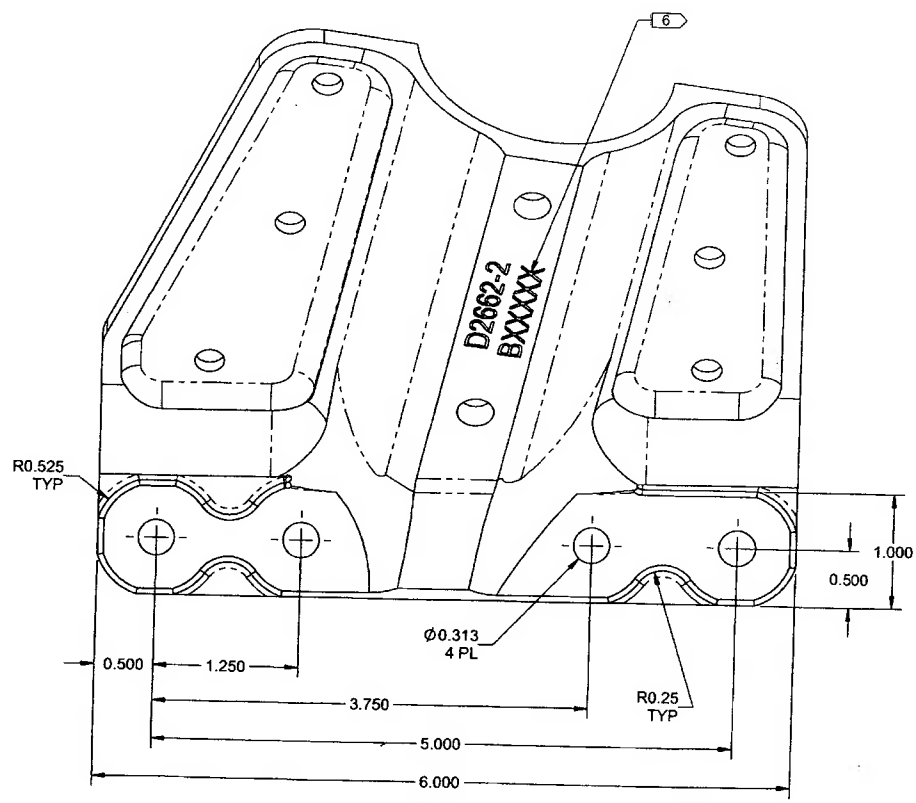
RELEASED
2011-11-16

D2662-2 SADDLE, INSIDE, RH

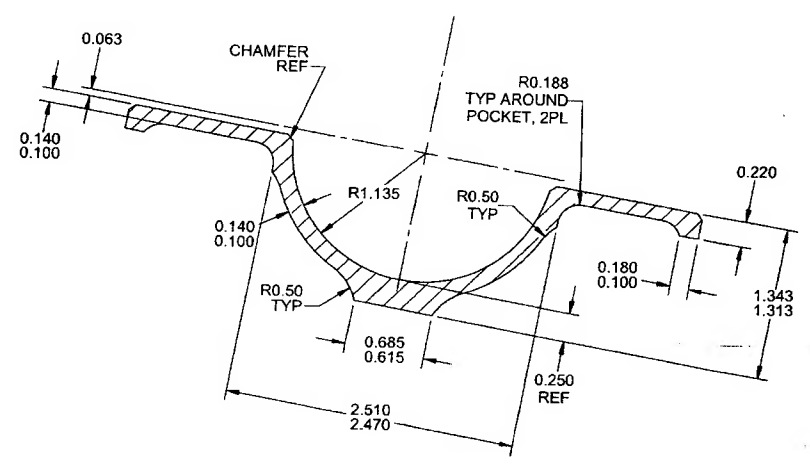
- D10Q-2 SADDLE, INSIDE, RH**
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209 MAKE FROM D6101-001 SADDLE BILLET
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
 - 7) WEIGHT: 0.66 lbs

| | | | |
|------------|----------|---|--------------|
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| DRAWN | | | SHEET 4 OF 5 |
| CHECKED | | | SCALE |
| MFG. APPR. | | | NTS |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.10.31 | | |

91224



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C C3-4
SCALE 1.5X

RELEASED
2011-11-16

| | | | |
|---|--|---------------------------------|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. D2662 | REV. E |
| MFG. APPR. | | | SHEET 5 OF 5 |
| APPROVED | | TITLE SADDLE, INSIDE | SCALE NTS |
| DE APPR. | | DATE 11.10.31 | |
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